

Work Order ID 70523

Friday, June 10, 2011 2:53:14 PM



Page 1

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP205-633-011 CHG001

Sub 6/24

Sub 11-6-22

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

Sub 11/06/22

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Sub 6/24

Sub

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70523

Friday, June 10, 2011 2:53:14 PM



Page 2

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location: _____								
	6								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/6/27 (4)

11/6/27

ME
11-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:53:20 PM

Page 1

Work Order ID: 70523

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:F02.07.11 Reformat; Removed D3010 ☐RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A Bolt		Purchased	No			110	Each	272.0000	1	4			
---------------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location Loc Qty Loc Code

ST357 254

116914 4

117619 100

117872 150

ST358 18

117313 18

AN4-5A Bolt		Purchased	No			110	Each	281.0000	2	8			
--------------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location Loc Qty Loc Code

ST355 200

117508 200

ST356 81

116191 31

116549 50

JB

JB 11/06/22

117619

116191

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:53:20 PM

Page 2

Work Order ID: 70523

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A

Purchased

No

110

Each

1,233.000

2

8



Bolt

Location

Loc Qty

Loc Code

ST356

1033

115936

33

116400

400

116924

400

117872

200

ST358

200

117514

200



116400

JB

AN4-7A

Purchased

No

110

Each

260.0000

2

8



Bolt

Location

Loc Qty

Loc Code

ST356

260

115373

10

117443

50

117514

200



117443

JB

AN5-14A

Purchased

No

110

Each

79.0000

1

4



Bolt

Location

Loc Qty

Loc Code

ST338

79

115374

79



115374

JB 11/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:53:21 PM

Page 3

Work Order ID: 70523

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

AN5-6A }
Bolt

Purchased No

110 Each

60.0000

1

4

✓

Location

Loc Qty

Loc Code

ST337

60

117313

10

117688

50

117313

AN960JD416 }
Washer

NAS1149D0463J Purchased

No

110 Each

0.0000

15

60

✓

AN960JD516 }
Washer

NAS1149D0563J Purchased

No

110 Each

0.0000

4

16

✓

D2021-101 }
Eyebolt

Manufactured No

110 Each

35.0000

1

4

✓

Location

Loc Qty

Loc Code

ST004

35

62464

5

69527

30

62464

D2022-101 }
Spacer

Manufactured No

110 Each

124.0000

2

8

✓

Location

Loc Qty

Loc Code

ST504

124

67768

4

69532

60

69824

60

69532

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:53:21 PM

Page 4

Work Order ID: 70523

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

D2022-103 Manufactured No 110 Each 45.0000 2 8 ✓ JB L
Spacer

Location	Loc Qty	Loc Code
ST005	45	
47964	5	
69550	40	

D2562-001 Manufactured No 110 Each 9.0000 1 4 ✓ JB L
Strut

Location	Loc Qty	Loc Code
ST264	9	
66832	1	
68899	8	

D2563 Manufactured No 110 Each 0.0000 1 4 ✓ JB L
Step Weldment Assembly

D2565-101 Manufactured No 110 Each 16.0000 1 4 ✓ JB L
Strut

Location	Loc Qty	Loc Code
ST270	16	
68900	8	
70190	8	

D2565-103 Manufactured No 110 Each 14.0000 1 4 ✓ JB L
Strut

Location	Loc Qty	Loc Code
ST270	14	
68901	6	
69526	8	

Friday, June 10, 2011 2:53:22 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:53:22 PM

Page 5

Work Order ID: 70523

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

S
D2565-105
Strut

Manufactured No

110 Each

15.0000



1

4

✓

JB

h

Location

Loc Qty

Loc Code

ST270

15

68902

3

69517

12

68902x3
69517x1

S
D2565-107
Strut

Manufactured No

110 Each

13.0000



1

4

✓

JB

h

Location

Loc Qty

Loc Code

ST270

13

69522

13

69522

S
D2565-109
Strut

Manufactured No

110 Each

17.0000



1

4

✓

JB

h

Location

Loc Qty

Loc Code

ST270

17

64797

1

68903

4

69524

12

68903

S
D2565-111
Strut

Manufactured No

110 Each

25.0000



1

4

✓

JB 11/06/22

Location

Loc Qty

Loc Code

ST270

25

68904

8

69523

10

69898

1

69949

1

70203

5

68904

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:53:22 PM

Page 6

Work Order ID: 70523

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

5,323.000

8

32



Nut



JB

Location

Loc Qty

Loc Code

ST300

5323

116823

23

117441

3000

117601

800

117885

1500

117441

MS21042L5

Purchased

No

110

Each

1,064.000

2

8



Nut



JB 11/06/22

Location

Loc Qty

Loc Code

ST300

1064

116105

104

116548

260

117441

500

117591

100

117611

100

116105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LISTS

REFERENCE ONLY

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B

Date: 07.08.21